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मानक

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“Step Out From the Old to the New”

IS 3777 (1994): Textiles - Dusters, cotton khadi, bleached
[TXD 8: Handloom and Khadi]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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IS 3777 : 1994

REAFFIRMED

2005

भारतीय मानक

वस्त्रादि — सूती खादी के विरंजित कपड़े के झाड़न — विशिष्ट

(पहला पुनरीक्षण)

Indian Standard

TEXTILES — DUSTERS, COTTON KHADI,
BLEACHED — SPECIFICATION

(*First Revision*)

UDC 677.21.074 : 648.526

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BUREAU OF INDIAN STANDARDS
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NEW DELHI 110002

May 1994

Price Group 2

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1966. This standard has been revised to overcome certain difficulties encountered by the khadi industry in implementation of this standard.

Following are the important changes carried out while revising this standard:

- a) For checking the conformity of the dusters to the requirements laid down in the standard, a provision has been made for testing of the samples in prevailing atmospheric conditions. However, in case of dispute, the samples shall be tested after conditioning in the standard atmospheric conditions.**
- b) The standard provides for agreement between the buyer and the seller with respect to permissible number of defects in the dusters.**

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

**AMENDMENT NO. 1 JULY 2000
TO
IS 3777 : 1994 TEXTILES — DUSTERS, COTTON
KHADI, BLEACHED — SPECIFICATION
(First Revision)**

(Page 2, Table 1, col 5) — Substitute '190' for '170'.

(TX 8)

Reprography Unit, BIS, New Delhi, India

**AMENDMENT NO. 2 MARCH 2002
TO
IS 3777 : 1994 TEXTILES — DUSTERS, COTTON
KHADI, BLEACHED — SPECIFICATION**

(First Revision)

{ Page 2, Table 1, col 4 and 5, Tolerance, percent on 'Picks/dm' and 'Mass g/m²' } — Substitute '±10' for '± 5' at both the places.

(TX 08)

Reprography Unit, BIS, New Delhi, India

Indian Standard

TEXTILES — DUSTERS, COTTON KHADI, BLEACHED — SPECIFICATION

(First Revision)

1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements of dusters, cotton khadi, bleached.

1.2 This standard does not specify the general appearance, feel, shade, etc, of the dusters.

2 REFERENCES

The Indian Standards listed at Annex A are necessary adjuncts to this standard.

3 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmospheric conditions for checking the conformity of the dusters to the standard. However, in case of dispute, the specimens shall be conditioned and tested in the standard atmosphere as specified in IS 6359 : 1971.

4 GENERAL REQUIREMENTS**4.1 Yarn**

The yarn used in the manufacture of dusters shall be hand-spun from clean carded cotton. It shall be reasonably even and free from leaf particles, slubs, neps and other spinning defects. The approximate count of warp and weft yarn is given in Table 1.

4.2 Dusters**4.2.1 Cloth**

The cloth used in the manufacture of dusters shall be woven in plain weave.

4.2.2 The dusters shall be free from blueing, dressing and filling materials and substances liable to cause subsequent tendering.

4.2.3 The transverse ends of the duster shall be hemmed to a depth of not less than 13 mm with raw edges having a turn-in of 6 mm. The stitching shall be firm and regular. The hemming shall be uniform and flat and the edges shall be properly secured.

4.2.4 The dusters, when visually examined, shall be reasonably free from spinning, weaving and processing defects.

5 REQUIREMENTS

5.1 Constructional particulars and breaking load of the dusters shall conform to the requirements specified in Table 1.

5.2 Dimensions

Length and width of the dusters when determined in accordance with the method given in Annex B shall be as agreed to between the buyer and the seller or as declared by the seller. However, a tolerance of ± 1 cm shall be permitted on length and width.

5.3 Sealed Sample

5.3.1 In order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel and shade, if a sample has been agreed upon and sealed, the supply shall also be in conformity with the sample in such respects.

5.3.2 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 INSPECTION

6.1 The dusters when visually inspected shall be free from the major flaws given in Annex C. However, permissible number of flaws per piece may be as agreed to between the buyer and the seller.

6.2 For details of the flaws mentioned in 6.1, a reference may be made to IS 4125 : 1987.

7 PACKING

Fold each piece of duster into a suitable size and arrange a number of dusters to make a bundle. Unless otherwise agreed, pack the bundles in conformity with the procedure laid down in IS 1347 : 1972.

8 MARKING

8.1 Each bundle of dusters shall be suitably marked with the following information:

- a) Name of the material for example, dusters, cotton khadi, bleached;
- b) Length (cm) and width (cm); and
- c) Indication of the source of manufacture.

Table 1 Constructional Particulars and Breaking Load Requirements or Dusters, Cotton Khadi, Bleached
(Clause 5.1)

	Count of Yarn (for Guidance only) Universal Count (Cotton Count)		Ends/dm	Picks/dm	Mass g/m ²	Breaking Load (on 10'0 × 20 cm Strips), N	
	Warp (1)	Weft (2)				Warp (6)	Weft (7)
	59 tex (10s Ne)	74 tex (8s Ne)	126	118	170	450	430
Tolerance, percent	—	—	± 5 (— — — — see Note — — — —)	± 5	± 5	— 15	— 15
Method of Test	—	—	IS 1963 : 1981		IS 1964 : 1970 or Annex B	IS 1969 : 1985	

NOTE — Any increase in values of ends/dm, picks/dm or mass (g/m²) beyond positive tolerance shall not be a cause of rejection of the dusters.

8.2 BIS Certification Marking

The product may also be marked with the Standard Mark.

8.2.1 The use of the Standard Mark is governed by the provisions of *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The details of conditions under which the licence for the use of Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

9 SAMPLING

9.1 Lot

The quantity of the dusters delivered to a buyer against one despatch note shall constitute a lot.

9.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

9.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with Table 2. These pieces shall

be selected from atleast 10 percent of the bales drawing equal numbers of pieces, as far as possible, from each bale.

Table 2 Sample Size and Permissible Number of Non-conforming Dusters
(Clause 9.3)

Lot Size	Sample Size	Permissible Number of Non-conforming Dusters	Sub-sample Size
(1)	(2)	(3)	(4)
Up to 100	5	0	3
101 to 300	8	0	4
301 to 500	13	1	5
501 and above	20	1	7

9.3.1 For selection of samples at random from the lot, procedure given in IS 4905 : 1968 may be followed.

9.4 Number of Samples and Criteria for Conformity

It shall be as follows:

Characteristics	Number of Samples	Criteria for Conformity
Ends, picks, mass, length, width and visual inspection	According to column 2 of Table 2	Number of non-conforming dusters shall not exceed the corresponding number given in column 3
Breaking load	According to column 4 of Table 2	Average value shall meet the requirement

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
1347 : 1972	Inland packaging of cotton cloth and yarn (<i>first revision</i>)	1969 : 1985	Methods for determination of breaking load and elongation of woven textile fabrics (<i>second revision</i>)
1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)	4125 : 1987	Glossary of terms pertaining to defects in fabrics (<i>first revision</i>)
1964 : 1970	Methods for determination of weight per square metre and weight per linear metre of fabrics (<i>first revision</i>)	4905 : 1968	Methods for random sampling
		6359 : 1971	Method for conditioning of textiles

ANNEX B

(Table 1 and Clause 5.2)

METHOD FOR DETERMINATION OF DIMENSIONS AND MASS OF THE DUSTER

B-1 DIMENSIONS

Lay flat a test specimen on a horizontal surface and render it free from all creases and wrinkles. Measure the length and width of the test specimen correct to the nearest 0.5 cm with a steel measuring scale, placed at right angles to the selvages at two different places in each direction of the test specimen. Calculate separately the average of the two readings in each direction. Determine similarly the length and width of the remaining

pieces.

B-2 MASS

Cut four specimens of 100 mm × 100 mm from a sample. Condition all the specimens in a desiccator charged with saturated solution of sodium nitrate at 27 ± 2°C for a period of 24 hours. Remove all the specimens from the desiccator and immediately determine their collective mass in weighing balance to the nearest 5 g. Calculate mass of the duster fabric in g/m².

ANNEX C

(Clause 6.1)

LIST OF MAJOR FLAWS

- | | |
|---|---|
| <ol style="list-style-type: none"> 1) More than two threads missing either in warp or weft way of the piece. 2) Smash definitely rupturing the texture of the fabric. 3) Hole, cut or tear. 4) Defective or damaged selvage. 5) Noticeable warp or weft float in the body of the fabric. | <ol style="list-style-type: none"> 6) Noticeable oil or other stain in the fabric. 7) Oily weft in the fabric. 8) Defective hemming. 9) Gout due to foreign matter, usually lint or waste woven into the fabric. 10) Any other defect which would affect the durability. |
|---|---|

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Indian Standards are reviewed periodically and revised, when necessary and amendments, if any, are issued from time to time. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition.

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